

Date: Wednesday, 12/14/2005 4:03:07 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE
Job Number	: 25240		
Estimate Number	: 10866		
P.O. Number	: N/A	Part Number	: D31821
This Issue	: 12/14/2005 S.O. No. : N/A	Drawing Number	: D3182 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/10/2006
Checked & Approved By	: <u>SEE COMMENT BELOW</u>	Qty:	11 Um: Each
Comment	: Est A 03.01.29 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 00000-298

Email or ship DXF file to vendor

Laser Cut D3182-1 per Dwg D3182

Material release note required

2.0	D31821F	Hinge
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Hinge

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions per template D3182-1T1

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PS Date: 06/01/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/14/2005 4:03:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 25240

Part Number: D31821

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS 3

C 206/01/23

(11)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

505 06/01/25

(11)

(11) 06/01/24

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

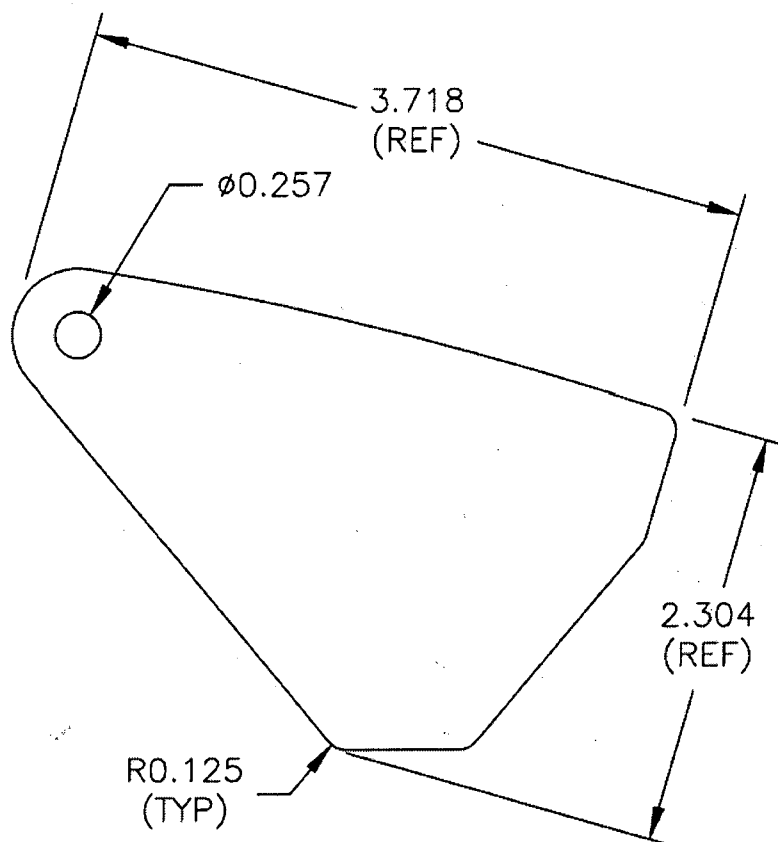
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3182	REV. A SHEET 1 OF 1
DATE 03.01.21		TITLE HINGE	SCALE 1:1
A	03.01.21	NEW ISSUE	

RELEASED
03.01.21 *[Signature]*



D3182-1 HINGE

- 1) MACHINE D3182-1 PER DART DWG "D3182-1.DWG"
- 2) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK
(REF DART SPEC. M304S11GA)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

NOT FOR CONSTRUCTION
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO
WITH IOWA

WORK OF
NO 25240

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SPECIFICATION :
CUSTOMER :

AISI 304
INTEGRIS METALS LTD

SPECIFICATION :		INTEGRIS METALS LTD					Physical Properties Tensile Test GL=50 m/m					Chemical Composition (%)								
SIZE	BUYER'S ITEM NUMBER	NO.	Weight (N.W.)		Heat No.	ID NO.	Y.S. (N/mm ²)	T.S. (N/mm ²)	EL. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100	
			KGS	LBS																
AISI 304 2B																				
11GA / 48" X 120"	(7427-6445)	1	1,404	3,095	YU136029	42S56953A-2122	275	630	51	83	164	4.1	52	109	31	3	820	1817	2.4	
11GA / 48" X 120"	(7427-6445)	1	1,051	2,317	YU136029	42S56953A-2123	275	630	51	83	164	4.1	52	109	31	3	820	1817	2.4	
11GA / 48" X 96"	(7427-6403)	1	1,398	3,082	YU136785	42S60093B-11	290	659	51	84	169	4.3	47	119	28	9	809	1827	2.9	
AISI 304 NO.4																				
16GA / 36" X 120"	(7426-6064)	1	1,396	3,078	YU282630	41S56329-22111	300	670	50	82	159	4.7	50	122	25	9	805	1813	2.9	

4 5,249 11,572

NO MERCURY CONTAMINATION

Bend test: good for all Heat NO.

Remarks:
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

PRODUCT IN ACCORDANCE WITH ASTM A240, A480,
A262E, ASME SA240, QQS766D.
P.O. NO.: 494470

YIEH MAU CORP.

Manager of Quality Assurance Section

11 ga 304 2B SS

200117

PO# 186, 215, 146, 248, 245